

Date: Wednesday, 23/07/2008 12:42:44 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BACKER PLATE
Job Number : 40471	
Estimate Number : 11803	
P.O. Number :	Part Number : D25283
This Issue : 23/07/2008 S.O. No. :	Drawing Number : D2528 REV C1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C1
Previous Run : 40471	Material :
Written By :	Due Date : 30/07/2008 Qty: 10 Um: Each
Checked & Approved By :	
Comment : Est:C 00.06.26 Removed P/O for powder coat EC Est Rev:D 08-07-23 now made on water jet DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S063	5052-H32 .063 Sheet
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Comment: Qty.: 0.0319 sf(s)/Unit Total : 0.3192 sf(s)

5052-H32 .063 Sheet

Material: 5052-H32 Sheet (QQ-A-250/8) 0.063" thick

(M5052H32S.063)

Batch: 103713 B 8-8-11

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D2528

Dwg Rev: C1

Prog Rev: C1

B 8-8-11

2-Deburr if necessary

8-8-12 JH

16

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

B 8-8-11

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 08/08/12 (+16)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

2/12/08 08/08/12

16

Date: Wednesday, 23/07/2008 12:42:44 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACKER PLATE

Job Number: 40471

Part Number: D25283

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 108523



16X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:20
320
10:50

m-f 08/08/13

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HP



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-13

16X

8.0

PACKAGING 1

PACKAGING RESOURCE #1



16X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

35

8/8/13

SD

9.0

QC21

FINAL INSPECTION/W/O RELEASE



16

Comment: FINAL INSPECTION/W/O RELEASE

2008/08/14

Job Completion



m-f 08-08-13

Date: Tuesday, 15/07/2008 9:13:54 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BACKER PLATE
Job Number	: 40471		
Estimate Number	: 11803		
P.O. Number	:	Part Number	: D25283
This Issue	: 15/07/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2528 REV C1
First Issue	: / /	Project Number	: N/A
Previous Run	: 26152	Drawing Revision	: C1
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 21/07/2008
Checked & Approved By	: <u>JUL 08.15.08</u>	Qty:	10
Comment	: Est:C 00.06.26 Removed P/O for powder coat EC	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M5052H32S063	5052-H32 .063 Sheet
-----	--------------	---------------------



Comment: Qty.: 0.0319 sf(s)/Unit Total: 0.3192 sf(s)

5052-H32 .063 Sheet

Material: 5052-H32 Sheet (QQ-A-250/8) 0.063" thick
 (M5052H32S.063)

Batch: _____

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blanks: 1.625" x 2.460" +/- .010"

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill holes as per Dwg D2528 using Drill Jig DT 8248B

Deburr

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	1.1	Water jet					
	1.2	Qc 2					
	1.3	Qc 8					
		*** perm. change ***	11	08/07/23			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:13:54 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACKER PLATE

Job Number: 40471

Part Number: D25283

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per CSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2528	REV. C SHEET 1 OF 1
DATE 98.12.10		TITLE BACKER PLATE	SCALE 1:1
A	96.12.12	NEW ISSUE	
B	97.10.10	CHANGE SIZE AND HOLE LOCATION	
C	98.12.10	ADD D2528-1 AND -3 (TSR A1037) UPDATED TOLERANCES	
CI	05.04.27	1.46 WAS 1.460; 1.00 WAS 1.000	

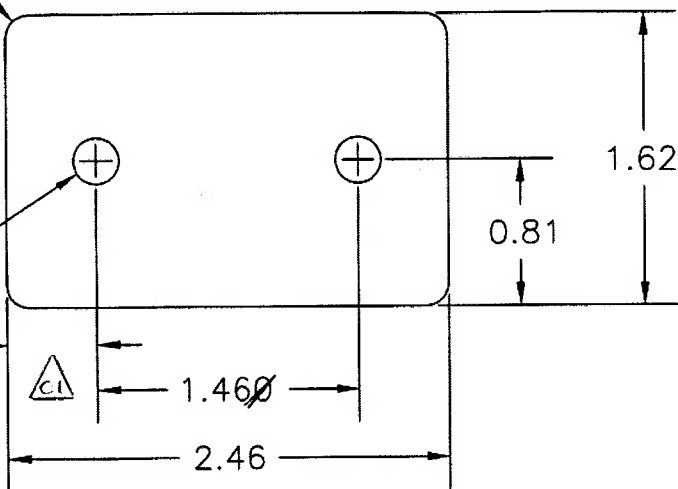
RELEASED
98.12.11 *KE*

R0.13 (TYP)

UNDER REVIEW
~~05.04.27~~
01.12.03

Ø0.257 (TYP)

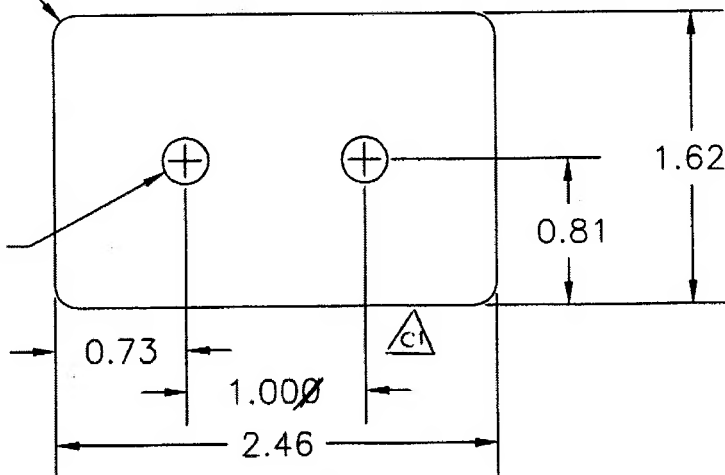
0.50



D2528-1

R0.13 (TYP)

Ø0.257 (TYP)



D2528-3

MATERIAL: 5052-H32 OR 5052-H34 (QQ-A-250/8) OR 2024-T3
(QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) 0.063 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

